

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029425**Date Inspected:** 12-Apr-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1550**Contractor:** USA Hoist**Location:** Crest Hill, IL

<b>CWI Name:</b>	Robert Zimny		
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>

<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>

**Bridge No:** 34-0006**Component:** SAS Tower Elevator**Summary of Items Observed:**

Quality Assurance Inspector (QAI) James Kent Smith was at the USA Hoist shop in Crest Hill, Illinois between the times noted above in order to monitor Quality Control functions and the in process work being performed by USA Hoist personnel. The following items were observed:

Matt Wasigi, identification letter "A" and Jose Dominquez, Identification letter "C":

Qualified Welders "A" and "C" were observed during various intervals during the day welding the gusset plates (item #3 and #4) to the mast post(s) (item #1) as shown on approved drawing 914202-01-LH. These gusset plates were tacked into position earlier as previous report from 4-8-13 stated. "A" and "C" were both observed by this QAI to be using the Welding Procedure Specification (WPS) FCAW3210 with the 1.1mm E71T-1C Familiarc DW-50 wire electrode in the 2F position. The shielding gas being used was noted a combination of 75% Argon and 25% CO2 with flow rate of 38 CFH. The welding parameters were measured by this QAI using a Fluke clamp on meter, and were found to be 26 volts and 190 amperes which are in compliance with the WPS noted above. Following the completion of each weld made by "A" and "C", this QAI observed them to be checking the finished weld sizes using a weld file gage to ensure the 1/4" file weld size required by the approved drawings was being maintained. All completed welds were visually observed by this QAI and weld size were gauged at random.

Genaro Ulloa, identification letter "4847":

QAI observed at various intervals during the day, "4847" tacking into position the following components to the completed welded mast sections; using the approved drawing 914202-01-LH. Item #'s 6,7,8,9 and 10 are the components that make up the bolting tube connections of the mast sections. Following the tacking of these components, "4847" was observed performing dimensional measurements on the items in position and checking to the approved drawing. Sections were set aside after tacking and measuring operations for final welding to be performed at a later date.

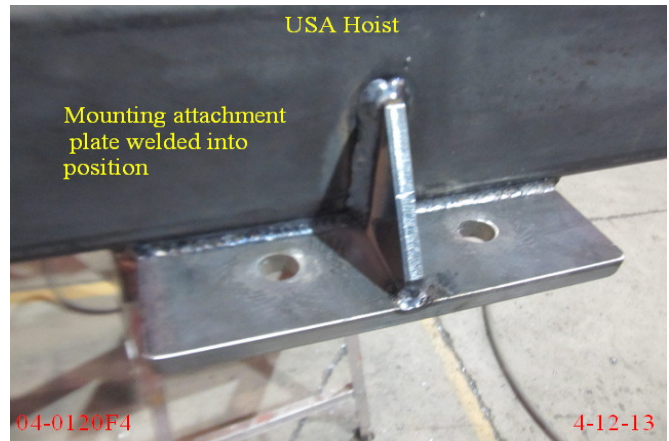
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## WELDING INSPECTION REPORT

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The completed and accepted work observed at this location appeared to be in compliance with the contract specifications. Unless otherwise noted, work observed on this date appeared to generally comply with special provisions and applicable contract documents.



### Summary of Conversations:

Basic conversation, fundamental to completion of the tasks at hand, occurred between this QAI and USA Hoist Management and Quality Control personnel.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916)764-6027, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Smith,James	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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